

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026051**Date Inspected:** 15-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	William Sherwood / SteveJensen			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG Components		

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection

11E/12E

This QA randomly observed ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. The joint being welded was a 14mm plate insert at the A deck to close the lifting lug deck penetration holes. This work was located at 10E-PP92-E3 and was performed in the flat position from the top side of the A deck.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=135/V=22.1).

This QA randomly observed ABF/JV qualified welder Mike Jiminez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint being welded was a 14mm plate insert at the A deck to close the lifting lug deck penetration holes. This work was located at 10E-PP80-E4 and was performed in the overhead position from the bottom side of the A deck.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=125/V=21).

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Note:

Approximately 8:15 this QA observed QC William Sherwood perform Magnetic Particle (MT) of completed welds at this panel point 80 location. The welds were completed the previous work day by ABF welding personnel Mike Jiminez #4671 and were ground flush prior to Mr. Sherwood performing MT. Mr. Sherwood recorded no rejectable indications at this time.

This QA randomly observed ABF/JV qualified welder Jimmy Zhen #6001 performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042B-1. The joints being welded were in the 3G vertical position at the side plate E1 on the outside of the OBG 11E/12E.

During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters. Welding parameters were recorded as (A=165/V=24.8).

Note:

Approximately 10:30 this QA randomly observed ABF welding personnel installing magnetic supports for the Bug-O track welding system as well as the thermo-couple heater blankets to the side plate E1 on the outside of the OBG 11E/12E.

Approximately 11:25 this QA randomly observed welding personnel had begun the welding process.
11W/12W

Approximately 8:30 this QA randomly observed ABF welding personnel performing plasma arc gouging to remove the backing bar from the side plate E1 at the on the outside of the splice weld at OBG 11E/12E.

At approximately 10:45 this QA randomly observed ABF/JV qualified welder Hua Qiang Huang #2930 performing joint preparation and fit up of longitudinal stiffener butt splices on the E side plate, 11W/12W segment splice location.

No welding was observed at this location by QA on this date.

At approximately 11:00 this QA randomly observed ABF/JV qualified welder Xiao Jian Wan #9677 performing joint preparation and fit up of longitudinal stiffener butt splices on the C side plate, 11W/12W segment splice location.

No welding was observed at this location by QA on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Clifford, William

Quality Assurance Inspector

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Levell,Bill

QA Reviewer